

Work Order ID 109865

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109865

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Item ID: D119-647-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 12/04/13 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/05/13 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3034 | Rev B |

| | | | | | | | | | |
|------------------|---|------|--|--|--|--|--|--|--|
| 100 | <u>IN 119-647 Rev A</u> | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | 0.00 | | | | | | | |
| DC | Memo <u>M.L.D.</u> | | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP D119-647-011 | | | | | | | | |

| | | | | | | | | | |
|--------------|----------|------|--|--|--|--|--|--|--|
| 160 | Pick Kit | 0.00 | | | | | | | |
| *160* | | 0.00 | | | | | | | |
| Packaging | Memo | | | | | | | | |
| Packaging | | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 170 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *170* | | 0.00 | | | | | | | |
| QC | Memo | | | | | | | | |
| Quality Control | | | | | | | | | |

3x **DAS 28 9-89** 13-12-31 **DAS 31 9-89**

(x3)

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Item ID: D119-647-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 12/04/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/05/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | Packaging | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D119-647-011 | | | | | | | | |
| | Location: <u>FG 012</u> | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 190 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

3x 8 14-01-0314-01-314-01-3

Picklist Print

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Work Order ID: 109865

109865

Parent Item: D119-647-011

D119-647-011

Parent Item Name: Bearpaw

Start Date: 12/04/13

Required Date: 12/05/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-02-02 JLM
 IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC
 IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC
 IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3034-1

Manufactured No

170

Each

0.0000

2

6

D3034-1

**

B109864

DAS
28
9-89

13-12-31

Bearpaw

D2182B

Manufactured No

170

f

299.0000

2.75

9

D2182B

**

Seal(SPer Foot)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST412

299

101827

1

108914

298

cut to 5.5" per dwg D2182 (D2182B055) {QTY 6}

D2274

Manufactured No

170

Each

513.0000

12

36

D2274

**

Radius Block

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST007

8

65047

8

ST008

493

108466

96

109534

397

DAS
31
9-89

Picklist Print

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Work Order ID: 109865

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Parent Item: D119-647-011

D119-647-011

Parent Item Name: Bearpaw

Start Date: 12/04/13

Required Date: 12/05/13

Start Qty: 3.00

Required Qty: 3.00

D2529 Manufactured No 170 Each 323.0000 12 36

D2529

Washer

**

DAS
28
9-89

13-12-31

Location Loc Qty Loc Code

ST011 323

108881 200

109580 123

D2947 Manufactured No 170 Each 51.0000 6 18

D2947

Clamp

**

DAS
28
9-89

Location Loc Qty Loc Code

ST456a 51

102376 1

104231 50

AN4-15A Purchased No 170 Each 142.0000 12 36

AN4-15A

Bolt

**

DAS
28
9-89

Location Loc Qty Loc Code

GA 100

120449 100

ST357 12

116786 4

m117423 8

ST514 30

m126105 30

NAS1149D0463J Purchased No 170 Each 484.0000 12 36

NAS1149D0463J

WASHER

**

DAS
28
9-89

Location Loc Qty Loc Code

ST510a 484

M127693 484

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Shop Packet Print

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Picklist Print

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Work Order ID: 109865

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Parent Item: D119-647-011

D119-647-011

Parent Item Name: Bearpaw

Start Date: 12/04/13

Required Date: 12/05/13

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

170

Each

3,700.000

12

36

MS21042L4

Locknut

DAS
28
9-89

13-12-31

Location

Loc Qty

Loc Code

| | | |
|---------|------|--|
| GA | 82 | |
| m126333 | 82 | |
| ST509 | 2000 | |
| m127255 | 2000 | |
| ST518 | 1618 | |
| m127376 | 1618 | |

DAS
21
89

36 X

*Ref only
8/4/01/62*

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

4. WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|--|--------------------|-----------------|-----------------------|--------------------|-------------------------|
| | | Arm | Moment | Arm | Moment |
| D119-647-011 Bearpaw Installation on model A119 aircraft | 15.4 lb 7.00 kg | 0.0 in 0.0 m | 0.0 lb-kp 0.0 m-kp | 173.2 in 4.40 m | 2667 in-lb 30.8 m-kp |

5. PARTS LIST

| Qty | Part Number | Description |
|-----|--------------|----------------------|
| X | D119-647-011 | BEARPAW INSTALLATION |
| 6 | D2182B055 | RUBBER CUSHION |
| 12 | D2274 | RADIUS BLOCK |
| 2 | D3034-1 | BEARPAW |
| 12 | D2529 | WASHER |
| 6 | D2947 | CLAMP |
| 12 | AN4-15A | BOLT |
| 12 | AN960JD416 | WASHERS |
| 12 | MS21042L4 | NUT (OR MS21042-4) |

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Revision: A

Date: 01.06.19

Work Order ID 109865

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Page 1

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 Revision ID: Stop ***NS2***
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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3034 | Rev B | | | | | | | | |
| 100 | <i>IN 119-647 Rev A</i> DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | Memo <i>N.L.</i> Photocopy bluefile & type labels per PPP D119-647-011 | 0.00 | | | CHG 002 | | | | |
| Document Control | | | | | | | | | |
| 160 | Pick Kit | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 170 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

3x *DAS* *28* *13-12-31*
9-00

